



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3699-041
Job Sheet 168979



Part No: D3699-041

Job Qty: 4 ea

Part Name: Support Assembly



Part Weight: 8 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/28/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A 08-04-25 new issue DD verified by:ec IPP Rev:B 08-07-14 revA as per dwg DD verified by:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/4/18	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	4 pcs		1/4/18	0.00	0.61	Waterjet1		SC
110	QC	4 pcs		1/4/18	0.00	0.00	QC2		SC DAS
120	QC	4 pcs		1/4/18	0.00	0.00	QC8		38
130	Brake NC	4 pcs		1/4/18	0.06	0.29	Brake NC 2		38
140	QC	4 pcs		1/4/18	0.00	0.00	QC5		38
150	Small Fab	4 pcs		1/4/18	0.00	0.21	Small Fab		38
160	QC	4 pcs		1/4/18	0.00	0.00	QC5		38
170	HandFinish	4 pcs		1/4/18	0.00	0.20	HandFinish1		38
180	Powdercoat	4 pcs		1/4/18	0.00	0.21	Powdercoat4		38
190	QC	4 pcs		1/4/18	0.00	0.00	QC3		38
200	Packaging	4 pcs		1/4/18	0.00	0.00	Packaging1		38
210	Small Fab	4 pcs		1/5/18	0.00	0.21	Small Fab		38
220	QC	4 pcs		1/5/18	0.00	0.00	QC5		38
230	Packaging	4 pcs		1/5/18	0.00	0.00	Packaging3		38
240	QC21-SA	4 Ea		1/5/18	0.00	0.00	QC21		38

M 135418.

START: 8:55 O.U.T: 320°

FINISH: 9:05

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MS20426AD3-3	8	810	0	0
210-Small Fab	M6061T6S.050	2	37	0	0
	MS21059L3	4	72	0	0

FM137659

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval			
Description Work		Disposition					
PART NO: D3699-041 Revision: Operation: Change No: Start up Operation Mfg Date: 12/01/17 Job No: 168979 Support Assembly S016541							
Completed By							
Lead hand / Supervisor Approval Verification							
QC / QA Coordinator Approval							
<table border="0" style="width:100%;"> <tr> <td style="width:50%; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-vericat ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:50%; vertical-align: top;"> Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ UTT-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>						Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-vericat ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ UTT-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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OTHER : _____							

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DART
 AEROSPACE
 S016541

DART AEROSPACE LTD		Work Order:	168979
Description: Support, LH		Part Number:	D3699-1
Inspection Dwg: D3699 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099	1		VR-Ø	
Ø0.180	+0.005/-0.001	0.182	1		Tape	
Ø0.238	+0.005/-0.001	0.238	1			
Ø1.525	+0.012/-0.001	1.526	1			
0.36	+/-0.030	0.367	1			
0.62	+/-0.030	0.628	1			
0.96	+/-0.030	0.967	1			
2.21	+/-0.030	2.22	1			
4.12	+/-0.030	4.125	1			
8.95	+/-0.030	8.957	1			
1.925	+/-0.010	1.926	1			
8.61	+/-0.030	8.615	1			
2.62	+/-0.030	2.631	1			
0.344	+/-0.010	0.345	1			
0.688	+/-0.010	0.690	1			
0.64	+/-0.030	0.647	1			
2.66	+/-0.030	2.671	1			
5.75	+/-0.030	5.762	1			
6.41	+/-0.030	6.422	1			
0.300	+/-0.010	0.302	1			
0.923	+/-0.010	0.925	1			
0.050	+/-0.010	0.049	1			

Measured by:	SK	Audited by:	38	Prototype Approval:	N/A
Date:	17/12/01	Date:	NOV 04 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	